Work Ord April 21, 2010		985								-47.			Page 1
Item ID: Revision ID: Item Name:	D3565-1 Wearplate			A	Accept				. .	Setup	Start Stop		
Start Date: Required Date: Reference:	21/04/2010	Start Qty: 8.00 Req'd Qty: 8.00				Cust Item Customer:							
Approvals:	Process Pla	n:	Date: _/	10-421	Tooling: SPC (Y/N):		Pate:		I	Run	Start Stop	1 10011101 0	
Sequence ID/ Work Center II	D	Operation Description		,	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr D3565	Rev	ision Nbr	ä				- h		,		v		
Waterjet FLOW CNC Waterj	iet LCZ	FLOW WATER JET Memo 1-Cut as per Deburr if ne	r Dwg D3565	□Dwg Rev:_	0.00 0.00 □Prog Rev:_	<u> </u>			B	<u> </u>	- المر- (7	·
QC Quality Control		QC2- Inspect parts off n Memo	nachine FAI/F	'AIB	0.00					10-	<u>4-</u> 2	л	
I													

120

QC8- Inspect parts - second check

Quality Control

Memo

W/0:57	1985	WORK ORDER CHA	NGES	erestile to the second			,
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/4/27	世纪	Took aty of For ac inspection emplade	2	10/4/27	4		10/04/25

Part No: <u>D3565-1</u> P	AR #: Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE		Description of NC		Corrective Action Section B		Verification	Annroyal	Annuaval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 57985

April 21, 2010 10:07:09 AM



Page 2

Item ID:

D3565-1

Accept

Setup Start

Stop

Stop

El 10-4-29

Reject



Revision ID:

Item Name:

Wearplate

Start Date:

21/04/2010

Start Qty: 8.00

Required Date: 28/04/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan: _____ Date:___

Tooling:

0.00

0.00

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Draw

Rev.

Plan

Code

Accept

Qty

Run Start

Reject

Qty



Number Stamp

Insp.

QC: _____ Date: ___

Sequence ID/

Work Center ID

130

Large Fab Large Fab

Large Fab

Operation

Description

Memo

1-Weld D3009-3 cups as per dwg D3565□2-Weld hard facing as per Dwg

D3565 using DT8991 jig□A/R 2059B Hard Coat rod

140

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

150

QC5- Inspect part completeness to step on W/O

Quality Control

Memo

W/O:			WO	RK ORDER CHANG	ES	,			
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			- Ot-Lean						
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA	:	_ Date: _	
	Resolution: D								
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC			Verifica			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
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Work Order ID 57985

April 21, 2010 10:07:09 AM



Page 3

Item ID:

D3565-1

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Wearplate

Required Date: 28/04/2010

21/04/2010

Start Oty: 8.00

Reg'd Otv: 8.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Powdercoat

Powder Coating

Operation Description

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

M112588

Set Un/ Run Hours

Draw Number

Draw Rev.

Plan Accept Oty Code

Reject Otv

Reject Number Stamp

Insp.

Memo START TIME:

=) H 10/04/30 0.00 7.004m OVEN TEMPERATURE:

0.00

7:30A4 DFINISH TIME:

Identify as per dwg & Stock Location 477 1

170 OC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

180

Packaging

Memo

0.00

0.00

10-5-4

Packaging

W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			the second							
Part No	:	PAR #:	Fault Cate	gory:	_ NCF	R: Yes I	No DQ	A:	Date:	
		esolution:								
NCR:				R NON-CONFORMA	ANCE	(NCR)			
DATE	STEP	Description of NC	on of NC Corrective Action Section B			Verification Appr			Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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Work Order ID 57985

April 21, 2010 10:07:09 AM

Required Date: 28/04/2010



Page 4

Item ID:

D3565-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Wearplate

21/04/2010

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference: **Approvals:**

Process Plan:

QC:

Operation

Description

Date:_____

Date: Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run

Start

Stop

Sequence ID/

Work Center ID

190

Memo

QC21- Final Inspection - Work Order Release

0.00

Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Quality Control

0.00

N 10.05.04

Dart Aerospace L	Ltd
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:	Date: _	
		lesolution:						
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)		
DATE	STEP	Description of NC			tion B	Verificatio	n Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		Chief Eng	QC Inspector
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Picklist Print

April 21, 2010 10:07:13 AM

Work Order ID: 57985

Parent Item:

Comments:

D3565-1

Parent Item Name:

Wearplate

IPP rev B

IPP Rev : A New Issue 07-01-16 JLM

IPP Rev:C

revB dwg 07.04.18 ec rev.c as per dwg 08-01-14 DD verified by:

IPP Rev: D QC5 added to step 8 08.12.22 KJ Verified by:

D3009-3

Manufactured

No

100

Each

398.0000 24.0000

Start Date: 21/04/2010

Start Qty: 8.00

Required Date: 28/04/2010

Required Qty: 8.00

Cup

		Warehouse	<u>L</u>	oc Oty	Loc Code		
	:	Location					
		Main Warehouse					
	· · · · · · · · · · · · · · · · · · ·	WA		398			
	Ì	42377		398			
Purchased	No		130	sf	0.0000	1.1368	
	:						

304/316 Sheet .063

M304S16GA

1310-4-07



Page 1

304.063 114467

114467

W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	B	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									1100 1119	
Part No	•	PAR #:	Fault Categ	ory:	NCR: Y	es N	o DQ	A:	_ Date: _	
		solution:								
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
DATE	CTED	Description of NC Corrective Action			Ver			ication Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	ription Sign & Date		Section C		Chief Eng	QC Inspector
-										
									}	

DART AEROSPACE LTD	Work Order:	57985
Description: Wearplate (R44)	Part Number:	D3565-1
Inspection Dwg: D3565 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

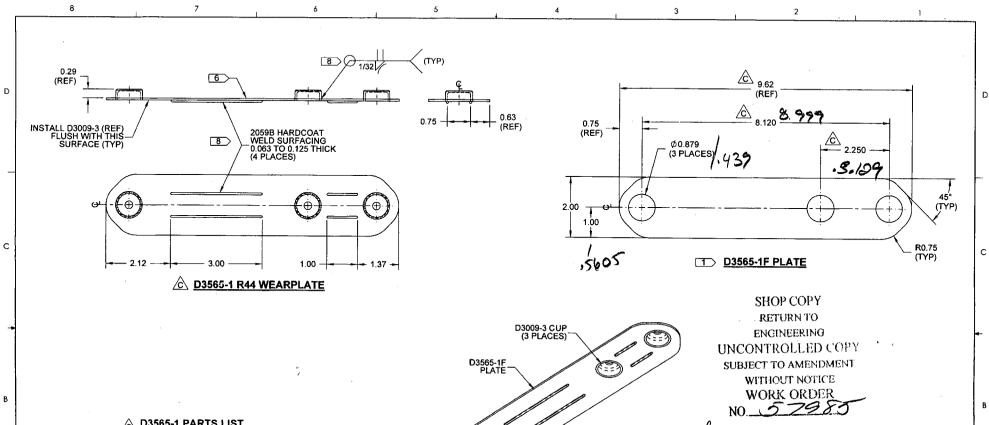
X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.879	+0.010/-0.001	. 883	8			
0.75	+/-0.030	:751	4			
1.00	+/-0.030	1,062	7			
2.00	+/-0.030	7.005	>		,	
2.250	+/-0.010	7.751	8			
8.120	+/-0.010	8,118	\forall			
9.62	+/-0.030	9.615	بيل			
0.063	+/-0.010	,00	7			
				,		

Measured by:	B	Audited by:	2	Prototype Approval:	N/A
Date:	10-4-57	Date:	10/04/27	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	09.05.07	New Issue	KJ/EC 🙀

		— - 											
W/O:			WC	WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #:	Fault Cate	gory:	NCI	R: Yes I	No DQ	A :	_ Date: _				
Resolution:			Disposition: Q			A: N/C Closed: Date:							
NCR:			WORK ORD	R NON-CONFORM	IANCE	(NCR							
DATE	STEP	P Description of NC Section A	Corrective Action Section B			0: 0	Verific	cation	ation Approval				
	0,2.		Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Section C		Chief Eng	Approval QC Inspector			
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		'											



C D3565-1 PARTS LIST

QTY -1	P/N DESCRIPTION					
х	D3565-1	R44 WEARPLATE				
1	D3565-1F	PLATE				
3	D3009-3	CUP				

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S16GA)
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.38 ibs

- 8) WELD PER DART QSI 004 9) PART IS SYMMETRIC ABOUT Q

REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	СВ	07.01.09
В	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	СВ	07.03.12
с	WEARPLATE NOW WELDED (C7); 8.120 WAS 8.220, 2.250 WAS 2.300 (D2); ADDED PARTS LIST (B7); UPDATED NOTES (A7)	мв	07.12.14

	1 00	07.01.00						
REV.		DESCRIPTION	BY	DATE				
DESIGN	CB	DART AEROSPACE LTD						
DRAWN	1	HAWKESBURY, ONTARIO, CANADA						
CHECKED	P	DRAWING NO.		REV. C				
MFG. APPR.		D3565	SHEET 1 OI					
APPROVED	900	TITLE		SCALE				
DE APPR.		R44 WEARPLATE		1:2				
DATE O7	12 14	COPYRIGHT © 2007 BY DART	AEROSPA C	E LTD				

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W/O:			ORK ORDER CHANG	iES					-	
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	egory:	_ NCR: Ye	es No	DQ/	\:	Date:	
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	P Description of NC Section A	Corrective Action Section B			Verif		ication	Approval	Approval
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